



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4276-1
Job Sheet 168933



Part No: D4276-1

Job Qty: 2 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/27/17

Job Tracking No:

Due Date: 12/8/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B 10.12.02 AS PER DWG
REV.A DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Machining		
100	Bandsaw	2 pcs	12/7/17	12/7/17	0.00	0.03	Bandsaw1		KT 17-11-28
110	CNC Vertical Machining	2 pcs	12/7/17	12/7/17	0.58	3.57	HAAS 1		KT - 17-11-28
120	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC2		KT - 17-11-28
130	QC	2 pcs	12/7/17	12/7/17	0.00	0.00	QC8		KT 17/12/04
140	HandFinish	2 pcs	12/7/17	12/7/17	0.00	0.24	HandFinish1		2017-12-04
145	Powdercoat	2 pcs	12/8/17	12/8/17	0.00	0.18	Powdercoat1		BK 17-12-5
150	QC	2 pcs	12/8/17	12/8/17	0.00	0.00	QC3		38
180	Packaging	2 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3	57463	50
190	QC21-SA	2 Ea	12/8/17	12/8/17	0.00	0.00	QC21		17/12/6

Part Op 100 - Cut Blank to 36.630"

Descriptions: 110 - 1-Machine per folio FB007

145 - MASK AS PER DWG

M 138367. START: 10:10 OUT: 300° FINISH: 10:40.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B1.000X04.000	6	22	0	0

Part Specifications

Specifications could not be found.

Plex 11/27/17 8:51 AM dart.poulin.mario

M134705-238
= 36,700 piece

SD 14386

FM 130013
= 36,700 piece

DART AEROSPACE LTD		Work Order:	168933
Description: Aft Beam		Part Number:	D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.754	✓		31006	H-G
20.500	+/-0.010	20.500	✓		" "	" "
Ø0.381	+0.000/-0.001	0.381	✓		✓	Ring
14.380	+/-0.010	14.380	✓		31006	H-G
R0.75	+/-0.030	R.0750	✓		✓	R-G
3.50	+/-0.030	3.500	✓		K1-05	vern.
16.38	+/-0.030	16.380	✓		31006	H-G
5.00	+/-0.030	5.00	✓		K1-05	vern.
0.75	+/-0.030	0.750	✓		" "	" "
2.75	+/-0.030	2.750	✓		" "	" "
3.00	+/-0.030	3.000	✓		" "	" "
1.250	+/-0.010	1.250	✓		" "	" "
4.50	+/-0.030	4.500	✓		" "	" "
0.734	+/-0.010	0.734	✓		" "	" "
0.108	+/-0.010	0.107	✓		31006	H-G
36.38	+/-0.030	36.38	✓		" "	" "
0.95	+/-0.030	0.950	✓		" "	" "
0.60	+/-0.030	0.600	✓		" "	" "
2.70	+/-0.030	2.700	✓		" "	" "
1.10	+/-0.030	1.100	✓		" "	" "
1.25	+/-0.030	1.250	✓		" "	" "
0.75	+/-0.030	0.750	✓		" "	" "
3.000	+/-0.010	3.000	✓		" "	" "
1.500	+/-0.010	1.500	✓		" "	" "
Ø0.191	+0.005/-0.001	0.192	✓		✓	Ring
2.300	+/-0.010	2.300	✓		31006	H-G
3.50	+/-0.030	3.500	✓		" "	" "
R0.60	+/-0.030	R.600	✓		✓	R-G
1.70	+/-0.030	1.700	✓		K1-05	vern.
0.65	DAS +/-0.030	0.652	✓		" "	" "

Measured by:	1 9-89	Audited by:	14 9-89	Preliminary Approval:	
Date:	17-11-28	Date:	17/12/04	Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	

DART
AEROSPACE
S014388



Aft Beam

PART NO:
Revision:
Operation:
Change No:

D4276-1

Start up Operation

Mfg Date: 11/27/17
Job No: 168933

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com